

Date: Tuesday, 8/21/2007 3:43:56 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	TOW RING
Job Number	34196		
Estimate Number	12928		
P.O. Number	N/A	Part Number	D2968043UP
This Issue	8/21/2007	S.O. No.	41A
Prsht Rev.	NC	Drawing Number	D2968
First Issue	N/A	Project Number	N/A
Previous Run	33362	Drawing Revision	B1
Written By		Material	N/A
Checked & Approved By		Due Date	9/20/2007
Comment	Est Rev:A	Qty:	20
	New Issue 07-07-04 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	34196A	STEM	✓ B34196 → 20 CPlot 10.11 (22)
			2x 07/09/09
Comment:	Sub-Component STEM D2968-3 B 33362 A / [REDACTED]		
2.0	34196B	RING	✓ B33362 → 20 CPlot 10.11 (22)
			2x 07/09/09
Comment:	Sub-Component RING D2968-5 B 30275 A / [REDACTED]		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	CPlot 10.11 (22)
			2x 07/09/09
Comment:	LARGE FABRICATION RESOURCE 1		
	Weld D2968-3 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-043		
Batch:	M102421		11/09/09
4.0	QC9	VISUAL WELDING INSPECTION	(22) 07-10-11
			2x
Comment:	VISUAL WELDING INSPECTION		
5.0	QC5	INSPECT WORK TO CURRENT STEP	(22) 07-10-11
			2x
Comment:	INSPECT WORK TO CURRENT STEP		
6.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH	(22) 07-10-11
			2x
Comment:	Sub-Contracting PURCHASING		
Issue P/O:	4785		
	Description: D2968-043 to heat treat to ultimate tensile strength		
	125ksi as per Dwg D2968		
	Conformity sheet required		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:56 PM

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Process Sheet

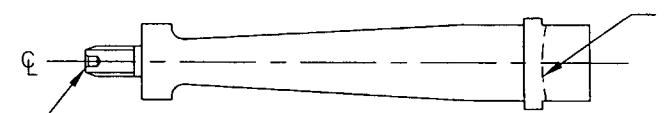
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: TOW RING
Job Number: 34196		Part Number: D2968043UP
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
	Issue P/O: <u>4784</u>	<u>C 207/10/11</u> (22)
	Cad Plate per QQ-P-416F Class I Type II	
	Conformity sheet required	
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached	<u>1/11/08 SP 225</u>
8.0	QC5 	INSPECT WORK TO CURRENT STEP <i>Parts were missing certs.</i> <u>1/11/19</u> (22)
	Comment: INSPECT WORK TO CURRENT STEP	
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>S444</u>	<u>AS 07/11/19</u>
10.0	QC21 	FINAL INSPECTION/W/O RELEASE  (22)
	Comment: FINAL INSPECTION/W/O RELEASE	<u>P 07/11/19</u>
Job Completion 		<u>U 07/11/19</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

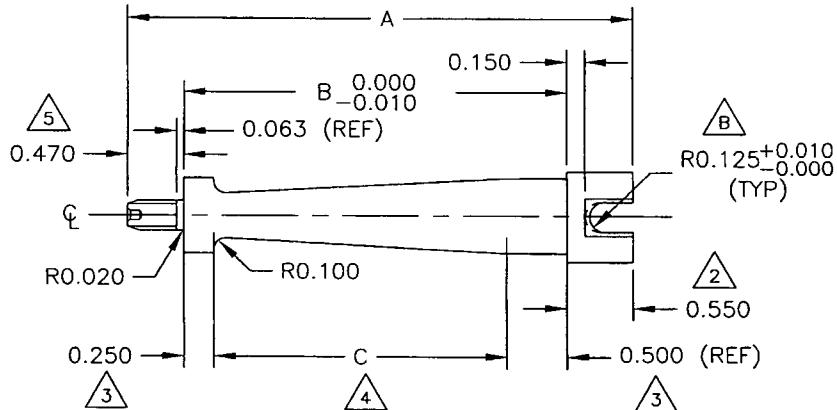
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



USE CENTER DRILL # 2
0.125 DEEP



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

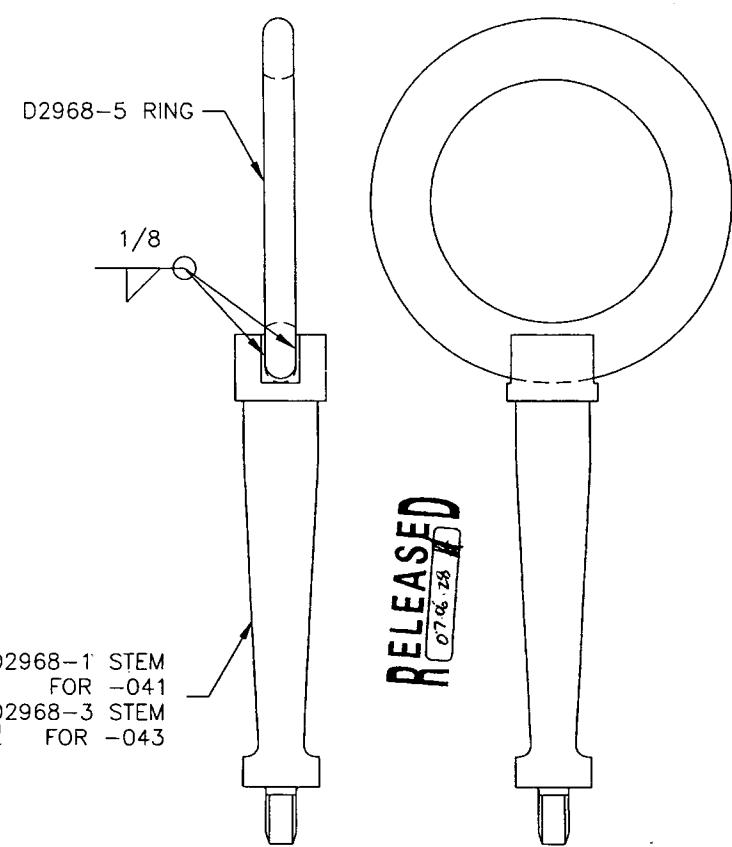
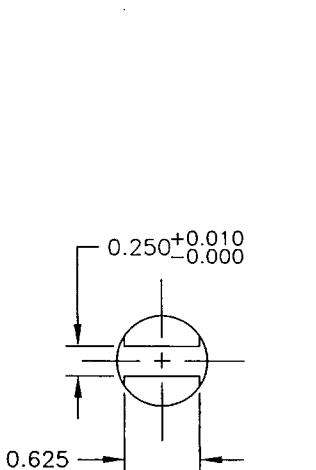
D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758
OR AMS 6348/6370/6528
(REF DART SPEC M4130N-RX.XXX)
- 2) Ø0.750 O.D.
- 3) Ø0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM Ø0.363 O.D.
TO Ø0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

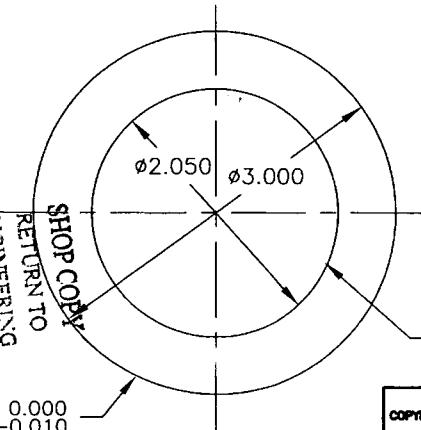
D2968-5 RING:

- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736
OR AMS 6360/6361/6362/6371/6373/6374
(REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
07-06-28

NO. 34196
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY
UNCONTROLLED COPY



D2968-5 RING

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D2968
DATE	TITLE		REV. C SHEET 1 OF 1 SCALE 1:1
07.04.17	TOW RING		



VAC AERO
INTERNATIONAL INC.

VAC AERO INT. INC. Fax: 905-865-8303

Nov 14 2007 05:44pm P002/002

RELEASE NOTE

GST No.: R105468102

OAK 91931-1

HEAD OFFICE
1371 STEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6I 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

10/25/2007
MM / DD / YYYY

PAGE: 1

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO DOMPLEX
4660 HICKMORE
ST. LAURENT QC

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
10/25/2007	PUROLATOR# 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00004785		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-043	TOW RING B34196	EA	22	22	
Process Specifications:	Procedure: 4047				
HEAT TREATED TO 175 KSI MIN. PER AMS 2759-1D					
100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5					
MATERIAL: 4130					
PS# 214746					

100% HARDNESS TESTED

04:22 PM
2017/10/25



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT
TREATING

MANCO
DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1B6
Tél.: 514-355-7867
Fax: 514-355-8750

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

#19460

Client / Customer

DRT Aerostar Ltd
PO 49786

Votre # de commande / Your purchase-order #

de la pièce / part

106015

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	Renault	Date, équipe / Date, shift	15 Nov 2007
Placage / Plating	QQP 416 P CLASS 1 TYPE II C		
Quantité totale / Total quantity	22	Quantité inspectée / Inspected quantity	22
Adhésion / Adhesion	Parfait		
Épaisseur / Thickness	L.C.D.	H.C.D.	Moy. / aver. 0.0005
Coulisses, taches / Leach, spots	Nor	Rugosité / Roughness	Nor
Quantité approuvée / Approved quantity	22	Quantité rejetée / Rejected quantity	

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX